



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D117-762-011
Job Sheet 170947



000616

Part No: D117-762-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 2/20/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG DSI9771 REV A, IIN-D117-762 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA DD verified by:ec IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP REV:E 15.06.11 IIN REV.D DD VERF:JLM IPP REV:F 17.01.17 PER CHG004 (dsi9771) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/19/18	2/19/18	0.00	0.00	Start Up Stores/Pkg-1		FEB 17 2018
110	Packaging	1 pcs	2/19/18	2/19/18	0.00	0.00	Packaging1-1		FEB 07 2018
120	QC	1 pcs	2/19/18	2/19/18	0.00	0.00	QC4		SMB
125	DC	1 pcs	2/20/18	2/20/18	0.00	1.52	DC		
130	Packaging	1 pcs	2/20/18	2/20/18	0.00	0.00	Packaging3-1		SMB
140	QC21-FG	1 Ea	2/20/18	2/20/18	0.00	0.00	QC21		21 FEB 2 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D117-762-011 CHG003
Descriptions: 130 - Identify and pack for shipping as per PPP D117-762-011 Location :FG081

18/23/12 FG081

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6C52A	Bolt	2 Ea (2 ea)	90-Start up Operation	
D117-762-041	Replacement Skidtube	1 Ea (1 ea)	90-Start up Operation	
D3512-041	Wearplate	2 Ea (2 ea)	90-Start up Operation	
D5300-1	GHL Bushing	2 Ea (2 ea)	90-Start up Operation	
D5301-1	GHL Plug	2 Ea (2 ea)	90-Start up Operation	
MS21043-6	Nut	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN6C52A	2	12	0
	D117-762-041	1	1	0
	D3512-041	2	4	0
	D5300-1	2	10	0
	D5301-1	2	5	0
	MS21043-6	2	71	0

Part Specifications

Specifications could not be found.

5044244x1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step #: _____	DISPOSITION PART NO: D117 - 762 - 011 Original Serial #: S040274 Revision: Operation: Start up Operation 02/07/18 Change No: CHG005 Job No: 170947	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Cosite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table> MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	tube ☐	Water Jet ☐	Engineering ☐	Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Cosite ☐	Supplier ☐																																													
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Root Cause <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;">P ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;">B ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;">C ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">C ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">C ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">C ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">C ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">H ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">V ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">N ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	P ☐	Design ☐	Operator ☐	B ☐	Doc/Data ☐	Offset/Setup ☐	C ☐	Equip/Tooling ☐	Supplier ☐	C ☐	Handling/Pre ☐	Training ☐	C ☐	Material ☐	Use for Testing ☐	C ☐	Internal Transport ☐	Poor Information ☐	C ☐	Tribal Knowledge ☐	Rushing ☐	H ☐	LOA ☐	Product Improvement ☐	V ☐	Substation ☐	Process Improvement ☐	N ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		ORY <table style="width: 100%; border: none;"> <tr> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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K6A 1K7
Canada

Master Unit 000616

Tel (613) 632-5200

Containers on Master Unit 000616				
Serial No	Part No	Customer Part No	Status	Quantity
S040177	AN6C52A	AN6C52A	Allocated	2
S040173	D3512-041		Allocated	2
S040170	D5300-1	D5300-1	Allocated	2
S040160	D5301-1	D5301-1	Allocated	2
S040155	MS21043-6		Allocated	2

S044244 D117-762011

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 4

REF FAA STC: SR01853SE

REF: TC LETTER OF ACCEPTANCE RDIMS-4374899

REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D117-762-XXX Skidtubes with a structurally superior lug design (D5300-1 Bushings, D5301-1 Plugs, AN6C52A Bolts, MS21043-6 Nuts) as shown in Figure 1. The new hardware will be included in D117-762-011 @ CHG 004 and subsequent.

2.0 INSTALLATION

For D117-762-011 @ CHG 004 and subsequent, the ground handling hardware should be installed as follows:

- 2.1 Loosely install (qty 2) D5300-1 GHL Bushing & (qty 2) D5301-1 GHL Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.2 Install (qty 2) AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.3 Torque AN6C52A Bolts 160 - 190 in-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

For D117-762-011 @ CHG 004 and subsequent, the Part List in IIN-D117-762 and ICA-D117-762 is modified as follows:

IS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C52A	BOLT
51A	2	D5300-1	GHL BUSHING
51B	2	D5301-1	GHL PLUG
52	2	MS21043-6	NUT

A	NEW ISSUE	RF	17.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	GHL UPGRADE KIT	NTS
DATE	17.01.09	COPYRIGHT ©2017 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

5.0 PARTS LIST

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN960C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE